

Work Order ID 50515

July 13, 2009 10:39:55 AM

Page 1

Item ID: D2224

Accept

Setup Start

Revision ID: E

Stop

Item Name: Rappel Anchor

Start Date: 7/17/09 Start Qty: 6.00

Cust Item ID:

Required Date: 7/24/09 Req'd Qty: 6.00

Customer:

Reference:

09-07-16

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2224

Rev E

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 2.8" *****Note grain direction *****

aml 09/07/20

6 0

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio D2224 & Dwg D2224-2-Deburr & Tumble

aml 09/07/20

6 0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

aml 09/07/20

6 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50515

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Start Date: 7/17/09

Start Qty: 6.00



Cust Item ID:

Required Date: 7/24/09

Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

SA 09/07/23

6

0

QC

Memo

0.00

Quality Control

140

Outsource process-Anodize per QSI017 4.1.10.1

0.00

Outsource4

Memo

0.00

Outsource process - Anodize

Issue P/O: 10/80 Red Anodize as per Dwg D2224 MIL-A-8625

CZ

09/08/07

6

150

Receive & Inspect for Damage & Mat'l Certs

0.00

Packaging

Memo

0.00

Packaging

PC 9/8/17 (6)

Work Order ID 50515



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Item ID: D2224
Revision ID: E
Item Name: Rappel Anchor

Accept



Setup Start



Stop



Start Date: 7/17/09 Start Qty: 6.00



Cust Item ID:

Required Date: 7/24/09 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo INSPECT ANODIZE	0.00 0.00	=> 802/08/18			(XG)	4		
170 Packaging Packaging	Identify as per dwg & Stock Location: 489 Memo	0.00 0.00				9/8/18	(60 SP)		
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				09/08/24	(HJ)		

MF 09-08-20

Picklist Print

July 13, 2009 10:39:54 AM

Page 1

Work Order ID: 50515

Parent Item: D2224RevE

Parent Item Name: Rappel Anchor

Comments:

Start Date: 7/17/09

Required Date: 7/24/09

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M7075T73B2.500X03.2 5		Purchased	No			100	f	5.3300	1.3958			



7075-T73 Bar 2.50 x 3.25



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

102694

5.33

5.33

(M107955)

mf
07/07/18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

* NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	50515
Description: Rappel Anchor		Part Number:	D2224
Inspection Dwg: D2224 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.188	+/-0.010	.182	✓			
0.050 x 45°	+/-0.010 x 0.5°	.044 x 45°	✓			
0.250	+/-0.010	.248	✓			
R0.500	+/-0.010	R.500	✓			
3.000	+/-0.010	3.001	✓			
Ø0.507	+0.008/-0.001	Ø.508	✓			
0.750	+/-0.010	.750	✓			
2.313	+/-0.010	2.316	✓			
1.687	+/-0.010	1.687	✓			
2.438	+/-0.010	2.441	✓			
1.125	+/-0.010	1.124	✓			
Ø0.313	+0.006/-0.001	Ø.313	✓			

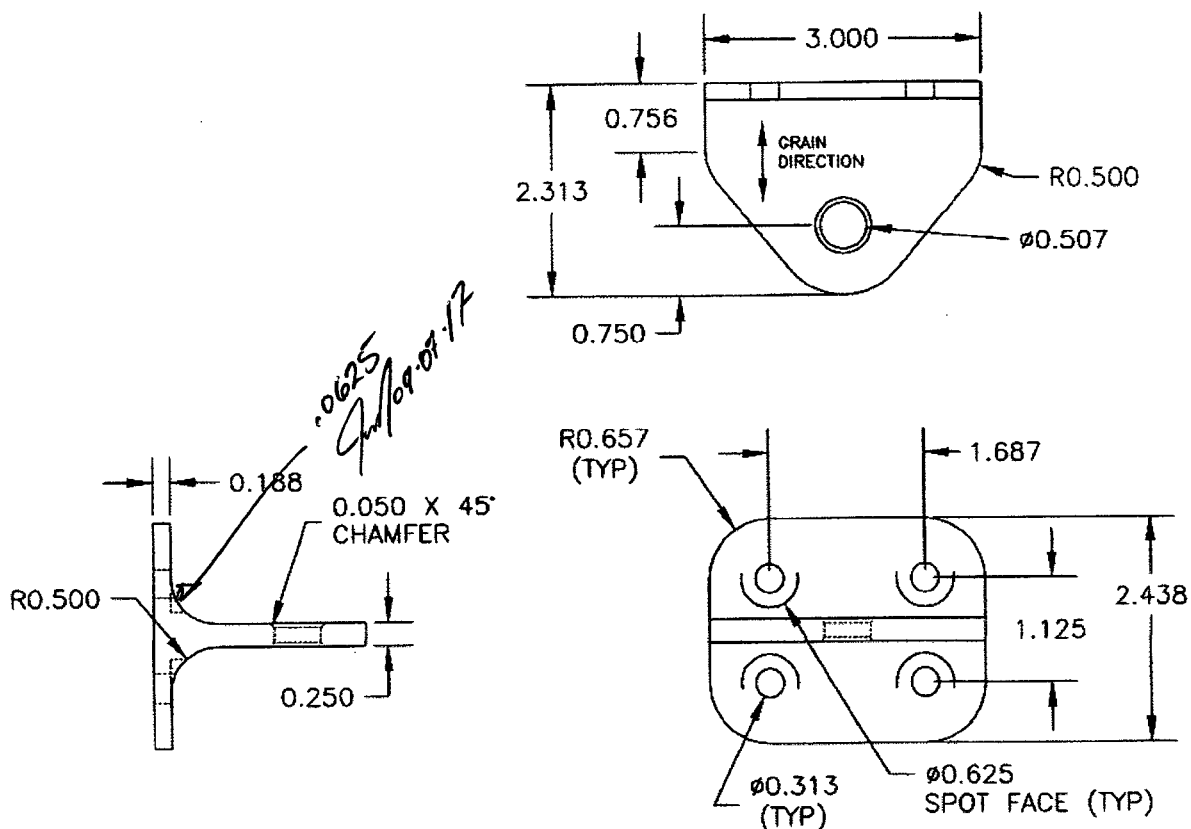
Measured by:	<i>ml</i>	Audited by:		Prototype Approval:	N/A
Date:	09/07/20	Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.11	New Issue	KJ/DD <i>[Signature]</i>	<i>[Signature]</i>



DESIGN HA	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED HA	DRAWING NO. D2224	REV. E SHEET 1 OF 1
DATE 99.04.29		TITLE RAPPEL ANCHOR	SCALE 1:2
A	94.03.10	NEW ISSUE	
B	95.04.11	D2227 WAS D2216	
C	96.06.17	ADDED D2224-60	
D	97.04.25	CHANGE TO T-SHAPE	
E	99.04.29	REVISE MATERIAL SPECIFICATIONS	

RELEASED
94.09.11 KE



MATERIAL: 7075-T7351 (QQ-A-200/11) OR 7075-T651 (QQ-A-200/11)
FINISH : ANODIZE RED PER MIL-A-8625
BREAK ALL UNMARKED EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

TNM**ANODISATION et PEINTURE TNM INC.**

C.O.F.C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified

approuvé NADCAP approved

76659

8/14/2009

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

**CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE****NO. DE COMMANDE: 513966
PURCHASE ORDER/**

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	16	16	D2224 B50813	- RED ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER
2	6	6	D2224 B50515	- RED ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER
3	30	30	D2224 B50878	- RED ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER

8/02/18

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.

Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed:

Directeur de la Qualité / Q.A. Manager

Part Acropora
1270 Aberdeen St.
Hawkesbury ent.
K6A-1K7

N° DE COMMANDE - ORDER NO.		DÉP. - DEPT.		DATE 09/08/07	
VENDU À - SOLD TO			EXPÉDIÉ À - SHIP TO Amodizing+Paint 21 Aviation RD		
ADRESSE - ADDRESS			ADRESSE - ADDRESS Peainte - Claire QC. H9R-4Z2		

DATE D'EXPÉDITION - SHIPPING DATE	VIA	CONDITIONS - TERMS	N° D'ENR. DE TAXE - TAX REG. NO.	VENDEUR - SALESPERSON
	P/O: 10180			514-429-7777

16	D2224	B50813
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6	D22224	B	50515
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30	D2224	B	50878
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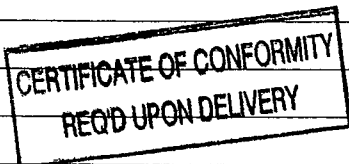
Red anadize as per

4mIL-A-8625F type 1 an

IB / II / IC / IIB class 2

please ship back:
pinoxolone acct # 7684382

thanks
cheryl



TPS/GST

TVP/PST

513966

SIGNATURE

N° LIC. - LIC. NO.

TOTAL **BlueLine**® DCB156**FORMULAIRE DE VENTE – SALES ORDER**

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